



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3072-2
Job Sheet 178631



Part No: D3072-2

Job Qty: 6 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP B 02.01.18 Flat pattern created on dash 101. NG IPP Rev:C 08-02-26 now water jet DD verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Waterjet		de 18/06/18
100	Waterjet	6 pcs	6/15/18	6/15/18	0.00	0.32	Waterjet1		de
110	QC	6 pcs	6/15/18	6/15/18	0.00	0.00	QC2 Waterjet-1		de JAS
120	QC	6 pcs	6/15/18	6/15/18	0.00	0.00	QC8-1		38
130	Small Fab	6 pcs	6/15/18	6/15/18	0.00	0.28	Small Fab-2		JB 38
140	QC	6 pcs	6/15/18	6/15/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs	6/15/18	6/15/18	0.00	0.17	HandFinish1		BEB 18-06-29
160	Powdercoat	6 pcs	6/15/18	6/15/18	0.00	0.14	Powdercoat4		de 18-7-3
170	QC	6 pcs	6/15/18	6/15/18	0.00	0.00	QC3		de 18-07-3
180	Packaging	6 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-1		de 18-07-3
190	QC21-SA	6 Ea	6/15/18	6/15/18	0.00	0.00	QC21		21 JUL 04 2018

Part Op 100 - 1-Cut as per Dwg D3072 (D3072-101 flat pattern) Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1- deburr if necessary 2- Bend as per dwg D3072

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - START TIME: 2:45 OVEN TEMPERATURE: 300° FINISH TIME: 3:15

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.090	5052-H32 .090 Sheet	.7002 sf (.1167 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M5052H32S.090	1	51	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
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Container No: S081013



Part: D3072-2

Job No: 178631

Serial No/Batch: S081013

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/13/18

306
3E
3AG
3E
3E-2

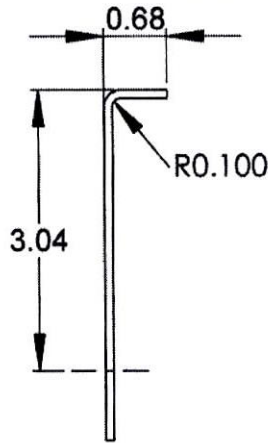
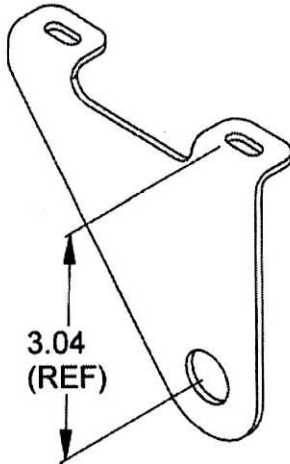
306
15
3E-2

1	Bracket	0.219Inches + 0.005 - 0.001	0.224 0.218	Diameter
2	Bracket	0.475Inches ± 0.010	0.485 0.465	
3	Bracket	0.640Inches + 0.008 - 0.001	0.648 0.639	Diameter
4	Bracket	0.512Inches ± 0.010	0.522 0.502	
5	Bracket	0.932Inches ± 0.010	0.942 0.922	
6	Bracket	4.324Inches ± 0.010	4.334 4.314	
7	Bracket	3.888Inches ± 0.010	3.898 3.878	
8	Bracket	0.975Inches ± 0.010	0.985 0.965	
9	Bracket	3.224Inches ± 0.010	3.234 3.214	
10	Bracket	0.350Inches ± 0.010	0.360 0.340	
11	Bracket	2.776Inches ± 0.010	2.786 2.766	
12	Bracket	3.800Inches ± 0.010	3.810 3.790	
13	Bracket	0.090Inches ± 0.010	0.100 0.080	

Plex 6/5/18 11:15 AM Dart.lajeunesse.marie



DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>		APPROVED <i>#</i>		DRAWING NO. D3072 REV. A SHEET 1 OF 1	
DATE 01.12.16			TITLE BRACKET SCALE 1:1		
A	01.12.16		NEW ISSUE		
0.68	A1 02.01.18		ADD FLAT PATTERN PART NUMBER <i># CP</i>		



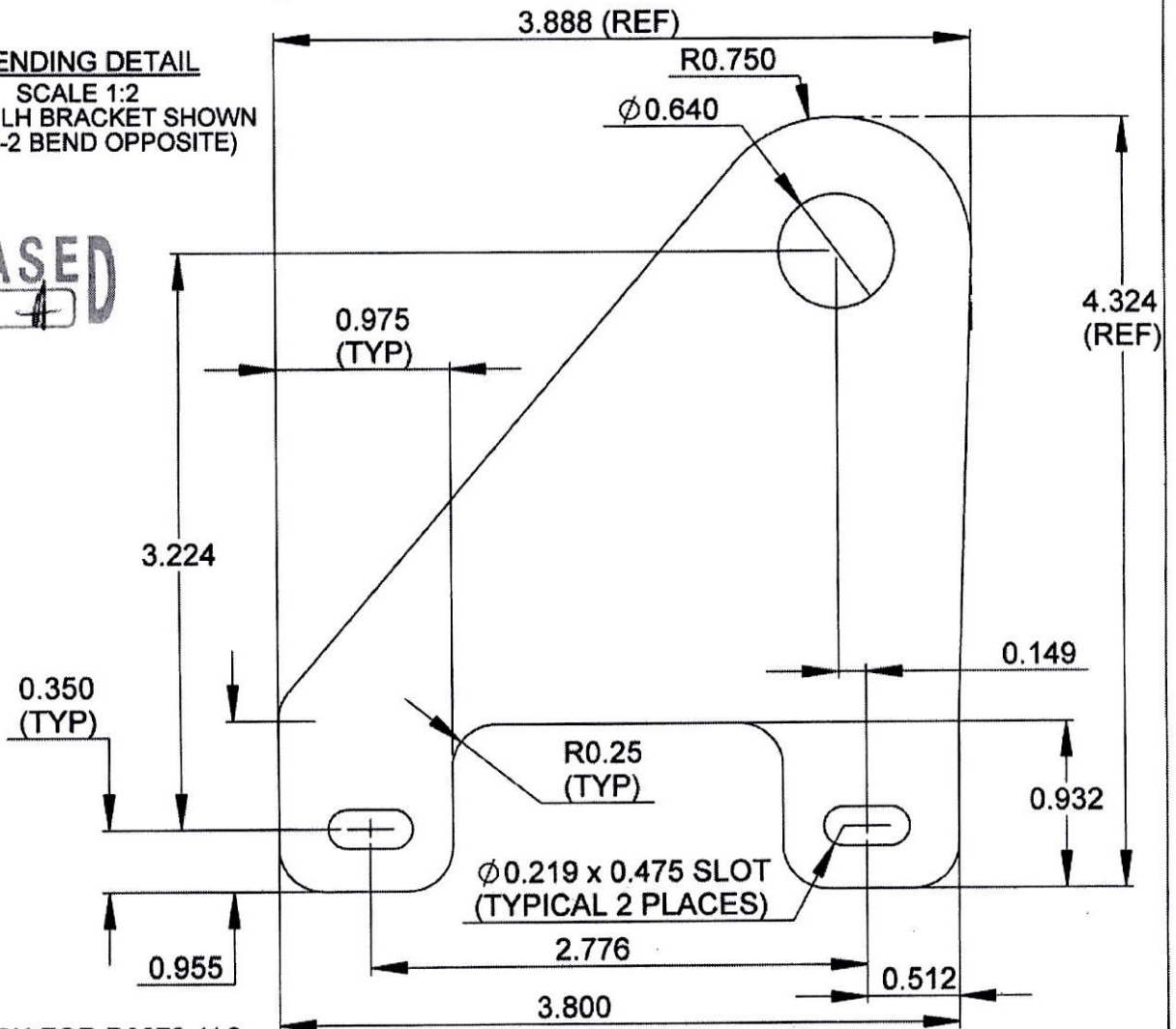
D3072-1/-2 BRACKET

- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/ QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COATBLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL

SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02.01.15 *#*



D3072-101

FLAT PATTERN FOR D3072-1/-2

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